

# Work Order ID 53489

November 6, 2009 8:44:12 AM



Page 1

Item ID: D3650-9

Accept



Setup Start



Revision ID: C

Stop



Item Name: Angle

Start Date: 06/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: BL

Date: 11-11-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3650	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3650 □ Dwg Rev: C □ Prog Rev: C □ 2-Deburr if necessary

304  
-010

Deburr M-L 09/11/19



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-11-18

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

⇒ 09/11/19



# Work Order ID 53489

November 6, 2009 8:44:12 AM



Page 2

Item ID: D3650-9

Accept



Setup Start



Revision ID: C

Stop



Item Name: Angle

Start Date: 06/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE  Memo Form as per Dwg D3650	0.00  0.00	58 09/11/23			7	0		
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	78 02/11/23			(48)	7		
150  Packaging Packaging	Identify as per dwg & Stock Location <u>189</u>  Memo	0.00  0.00	164/4/23 (8)						

**Work Order ID 53489**

November 6, 2009 8:44:12 AM



Page 3

Item ID: D3650-9

Revision ID: C

Item Name: Angle

Start Date: 06/11/2009 Start Qty: 4.00

Required Date: 13/11/2009 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

09/11/24

PH/09-11-23 (8)

# Picklist Print

November 6, 2009 8:44:16 AM

Page 1

Work Order ID: 53489



Parent Item: D3650-9RevC



Parent Item Name: Angle

Start Date: 06/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

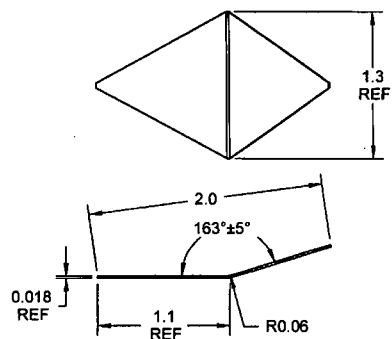
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S26GA 		Purchased	No			110	sf	186.4358	0.2147	.4294		
304/316 0.018 SHEET											11-11-10	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	186.4358	
105591	0.39	
107021	1.21	
108415	3.19	
109398	85.6458	
112885	96	

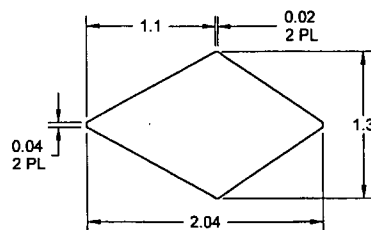
109398

8

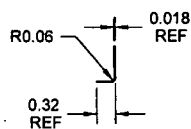




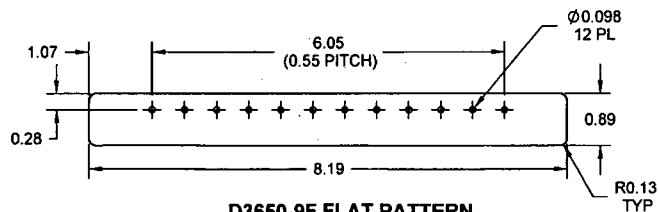
**D3650-11 FILLER PLATE**  
(MAKE FROM D3650-11F FLAT PATTERN)



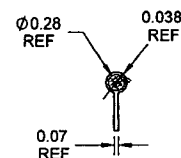
**D3650-11F FLAT PATTERN**



**D3650-9 ANGLE**  
(MAKE FROM D3650-9F FLAT PATTERN)



**D3650-9F FLAT PATTERN**



**D3650-7-8.19 SEAL**

**D3650-7-8.19 NOTES:**

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)  
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI.018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX  
WHERE X.XX = LENGTH IN INCHES  
EG. 12.50" LONG = D3650-7-12.50

**D3650-9 & D3650-11 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,  
PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI.018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb  
D3650-11 WEIGHT: 0.007 lb

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53989  
PL 09-11-6

DEO ATTACHED

RELEASED  
08/10/14

UNDER REVIEW  
08/02/14  
OK 08/16/14

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<u>[Signature]</u>	DRAWING NO. <b>D3650</b>	REV. C SHEET 9 OF 9
MFG. APPR.	<u>[Signature]</u>	TITLE <b>TOP PANEL ASSEMBLY</b>	SCALE NTS
DE APPR.	<u>[Signature]</u>	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	<b>08.10.14</b>		

DRAWING NO. D3650	TITLE TOP PANEL ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3650-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN CP	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 09.06.12	DATE 04.06.15	DATE 09.06.15	DATE 09/06/15	DATE 09/06/15			

**TO AMEND D3650-5 FWD PANEL:**

REF PAR 09-008. THE QTY(12) NAS1149CN432R WASHERS ARE REPLACED WITH QTY(1) D3893-1 DOUBLER. THE QTY(12) MS20615-4M5 RIVETS ARE REPLACED WITH QTY(12) NAS9307M-4-03 RIVETS. LOCATION OF THE DOUBLER IS SHOWN IN THE AMENDED DETAIL F (DWG SHEET 7) BELOW. THE PARTS LIST FOR D3650-5 IS AMENDED AS FOLLOWS:

**IS:**

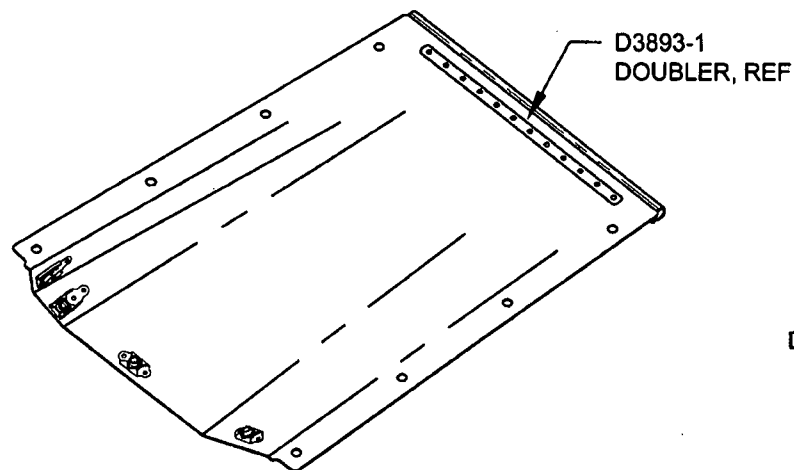
QTY	PART NUMBER	DESCRIPTION
-5		
1	D3893-1	DOUBLER
12	NAS9307M-4-03	RIVET (OR CR3523-4-03)

**WAS:**

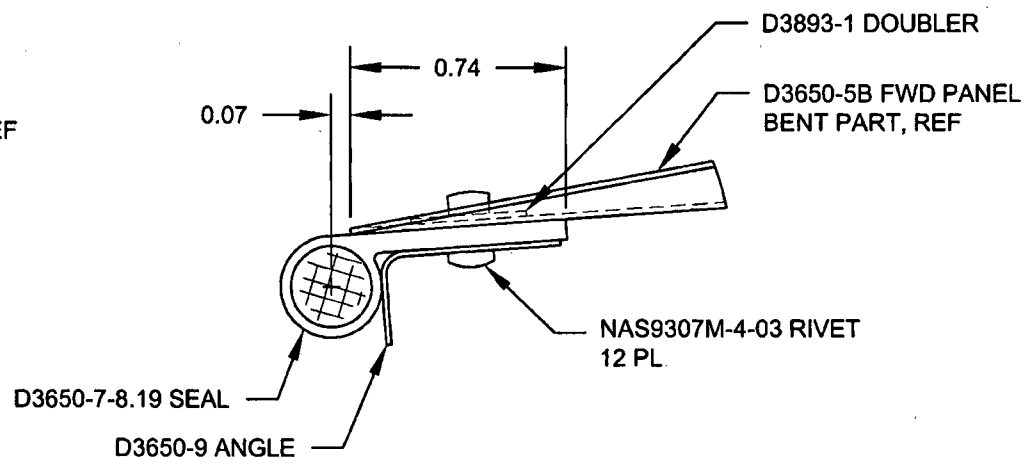
QTY	PART NUMBER	DESCRIPTION
-5		
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET

**RELEASED**  
09/06/15

W/O 53489



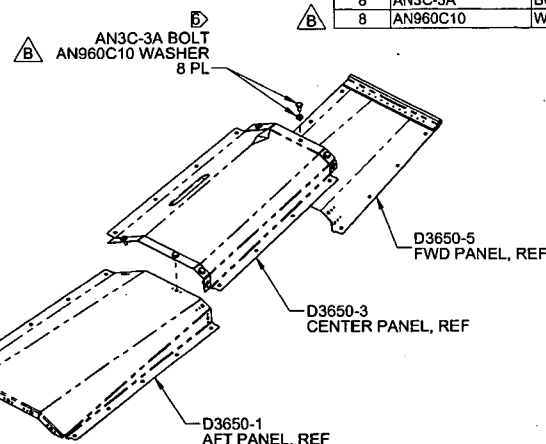
**D3650-5 FWD PANEL**



**DETAIL F** C5-7  
SCALE 3.5X

8 7 6 5 4 3 2 1

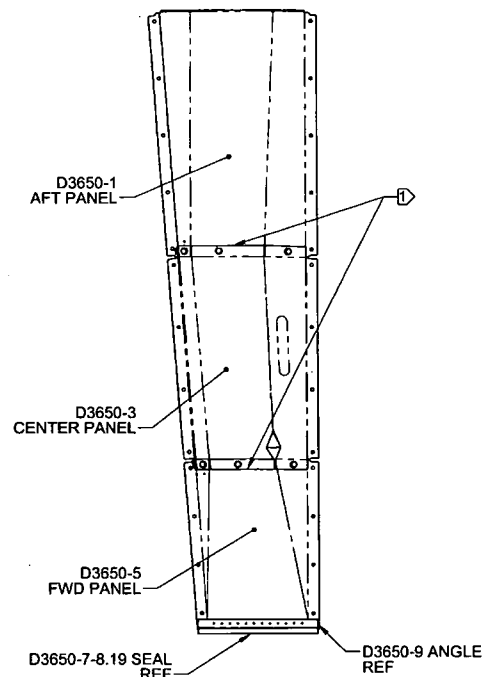
QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER



DEO ATTACHED

UNDER REVIEW  
OK 07.05.07  
BGR 05.00.08

RELEASED  
08.11.17



**D3650-041 TUNNEL TOP PANEL ASSEMBLY**

**NOTES:**

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

C	REFORMATTED TO NEW STANDARDS; RELOCATED PART LIST (ZN D2-2); ADDED SECTION VIEW J-J & REVISE DIMENSIONS (ZN B7-5, C4-5); ADDED RECESS LOCATION & REVISED DIMENSIONS (ZN C6-6, D5-6); MS20615-4MS WAS CR3523-4-03 & NAS1149CN432R WAS AN960C4 (ZN D5-7; B5-7; B8-7)	RF	08.10.14
B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOFF TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL 1 SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS O? D3650-11/-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.14		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3650** REV. C  
SHEET 1 OF 9

TITLE **TOP PANEL ASSEMBLY** SCALE 1:8

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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

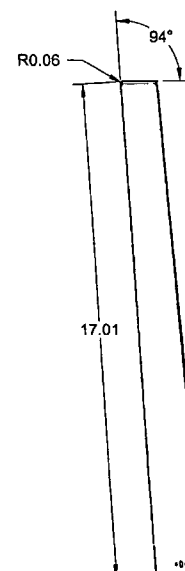
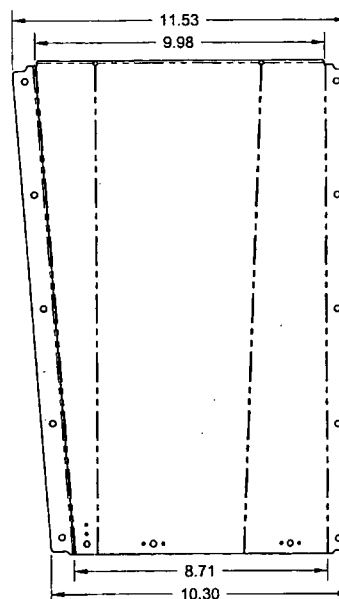
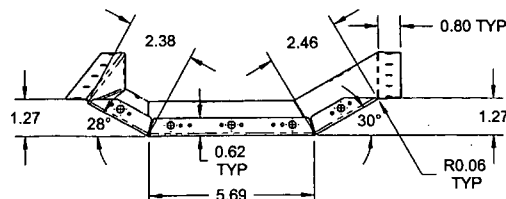
QTY	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

MS21060-3K NUTPLATE  
MS20427M3-3 RIVET, 2 PL  
6 PL

D3650-1B  
AFT PANEL BENT PART

MS21062-3K NUTPLATE  
MS20427M3-3 RIVET, 2PL  
3 PL

**D3650-1 AFT PANEL**



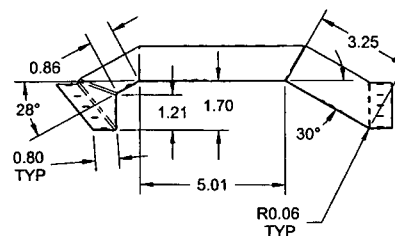
DEO ATTACHED

UNDER REVIEW

RELEASED

**D3650-1B AFT PANEL BENT PART**  
(MAKE FROM D3650-1F FLAT PATTERN)

- NOTES:
- 1) FINISH: NONE
  - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 5) IDENTIFICATION: NONE
  - 6) WEIGHT: 1.3 lbs

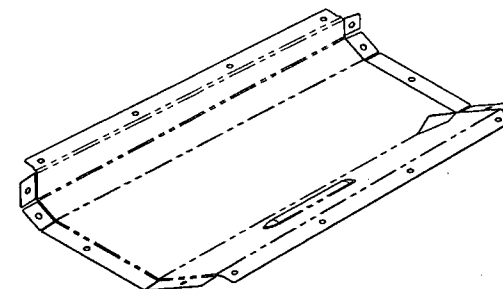
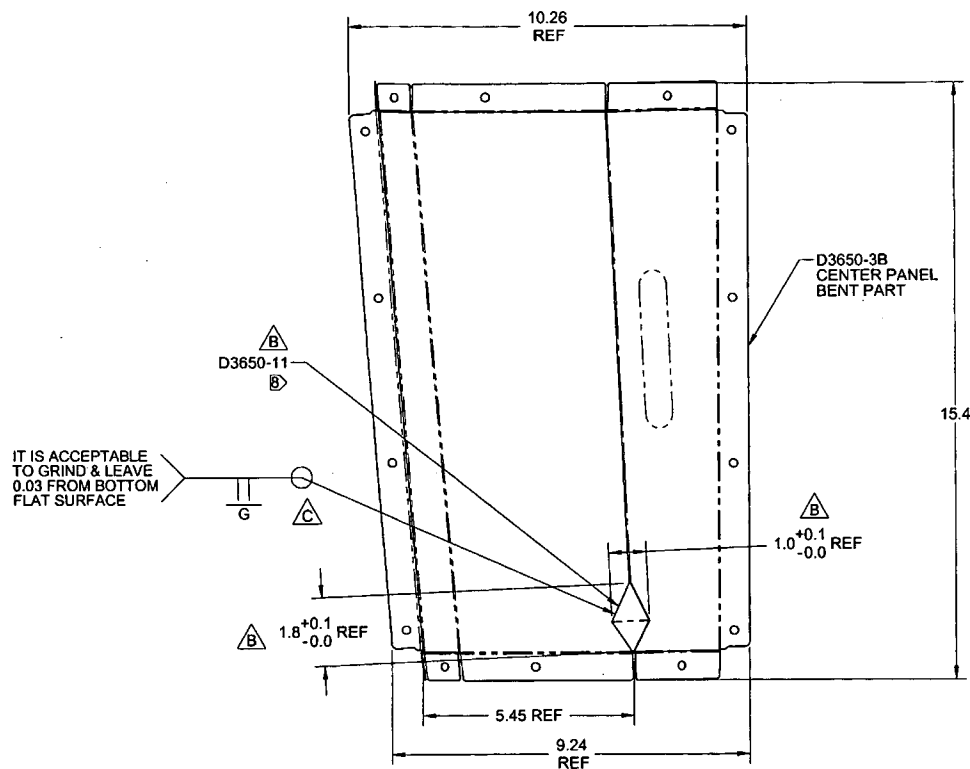


DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



QTY -3	PART NUMBER	DESCRIPTION
X	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE



**D3650-3 CENTER PANEL**  
(LOOKING FROM OUT SIDE SURFACE)

**NOTES:**

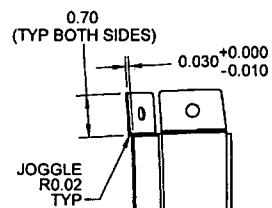
- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED

DEO ATTACHED

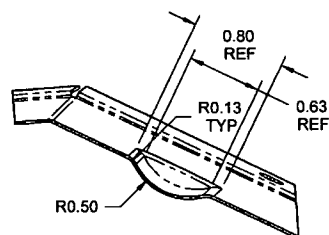
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08/11/17

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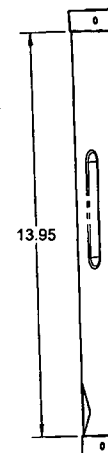
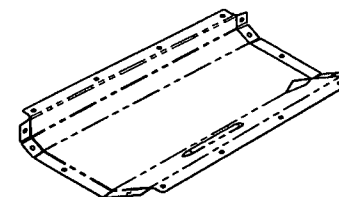
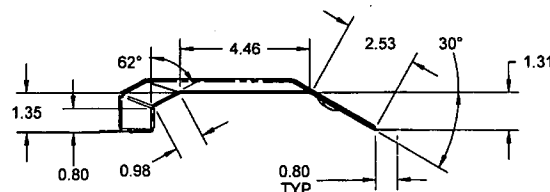
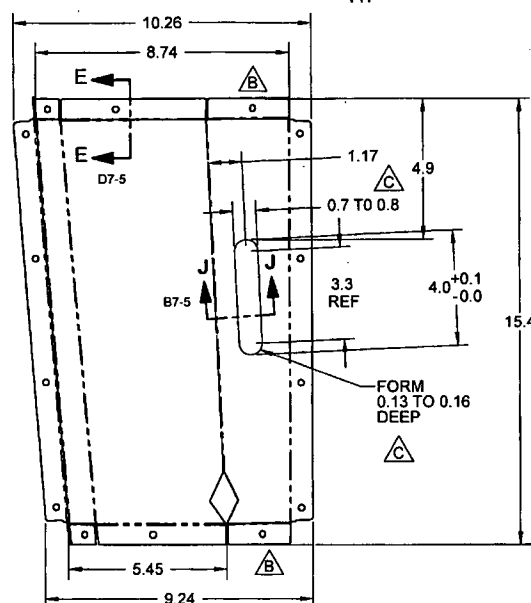
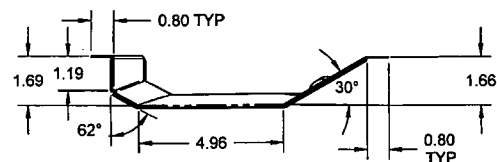
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DRAWN	RF		
CHECKED		DRAWING NO. D3650	REV. C
MFG. APPR.		SHEET 4 OF 9	
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
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**SECTION E-E** D5-5  
SCALE 2X



**SECTION J-J** C5-5  
SCALE 3.5X



- NOTES:  
1) FINISH: NONE  
2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) UNITS: INCHES UNLESS OTHERWISE NOTED  
4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
5) IDENTIFICATION: NONE

**D3650-3B CENTER PANEL BENT PART**  
(MAKE FROM D3650-3F FLAT PATTERN)

UNDER REVIEW

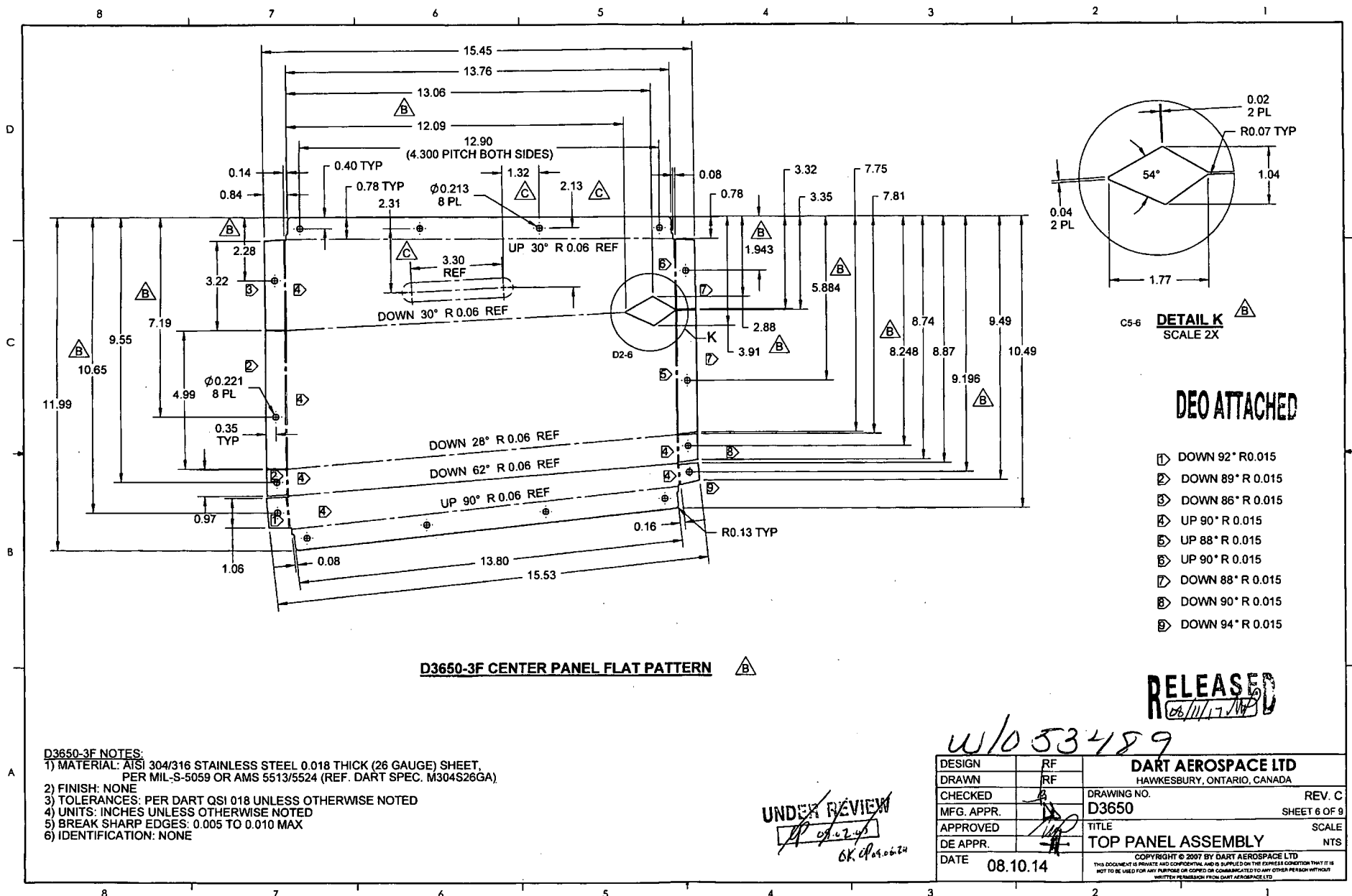
AP of J. W. OK 08.10.14

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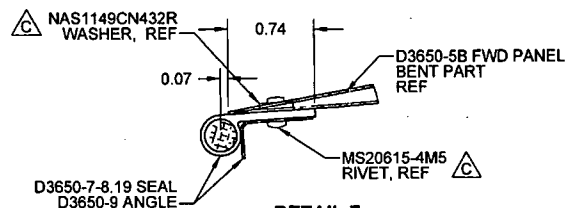
W/D 53489

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DRAWN	RF			
CHECKED			DRAWING NO.	REV. C
MFG. APPR.			<b>D3650</b>	SHEET 5 OF 9
APPROVED			TITLE	SCALE
DE APPR.			<b>TOP PANEL ASSEMBLY</b>	NTS
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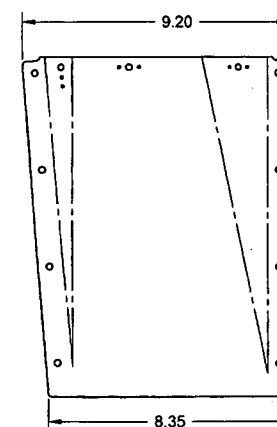
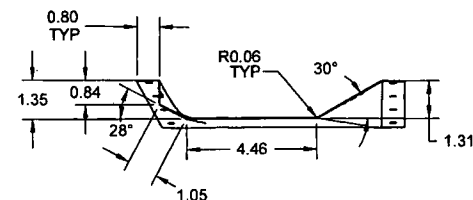


MS21062-3K NUTPLATE  
MS20427M3-3 RIVET, 2 PL  
2 PL

MS21060-3K NUTPLATE  
MS20427M3-3 RIVET, 2 PL  
2 PL



DETAIL F  
SCALE 3.5X



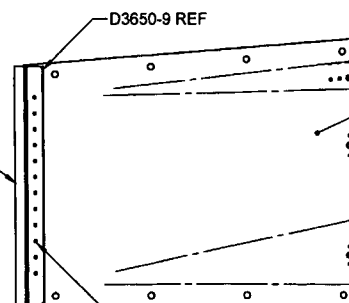
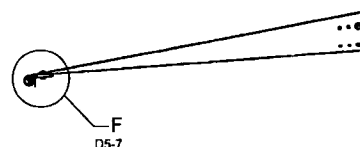
DEO ATTACHED

D3650-5B FWD PANEL BENT PART  
(MAKE FROM D3650-5F FLAT PATTERN)

PART LIST

QTY	PART NUMBER	DESCRIPTION
5	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

D3650-7-8.19  
REF



D3650-5 FWD PANEL

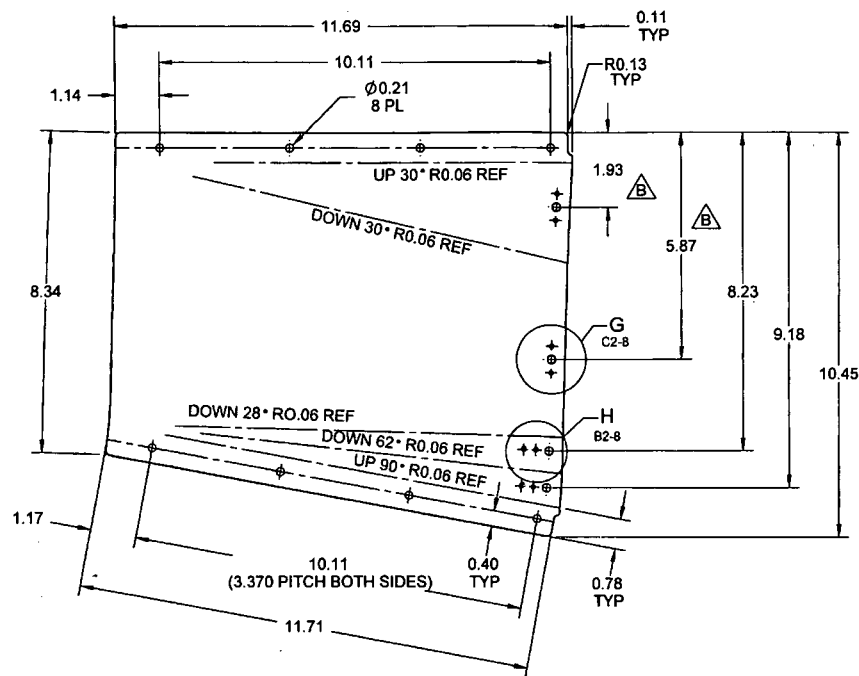
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs

UNDER REVIEW  
10/09/05  
02/09/05

RELEASED  
08/11/17

DESIGN	RF	DART AEROSPACE LTD	REV. C
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	SHEET 7 OF 9
MFG. APPR.		D3650	
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
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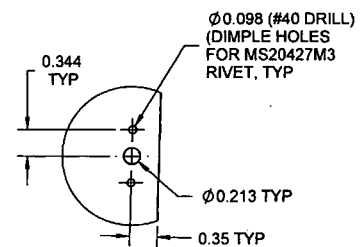
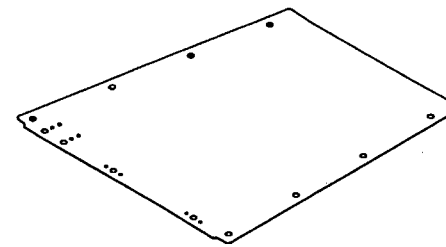


**D3650-5F FLAT PATTERN**

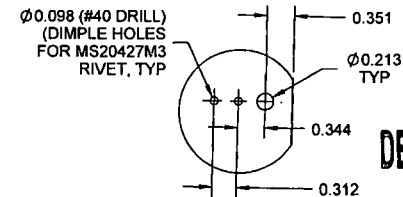
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

**UNDER REVIEW**  
*[Signature]*  
 CK 4/16/24



**DETAIL G**  
 2 PL  
 SCALE 1.5X

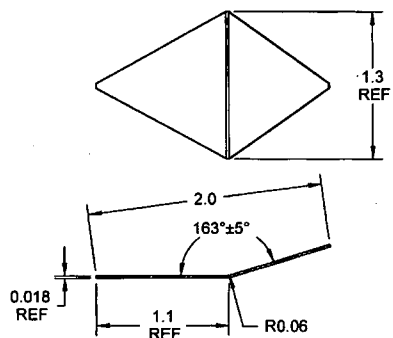


**DETAIL H**  
 2 PL  
 SCALE 1.5X

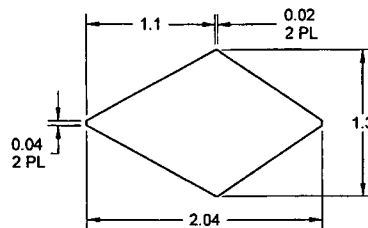
**DEO ATTACHED**

**RELEASED**  
 08/11/17

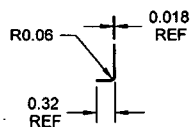
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	<b>D3650</b>	SHEET 8 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>TOP PANEL ASSEMBLY</b>	NTS
DATE	<b>08.10.14</b>	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



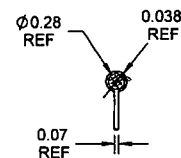
**D3650-11 FILLER PLATE**  
(MAKE FROM D3650-11F FLAT PATTERN)



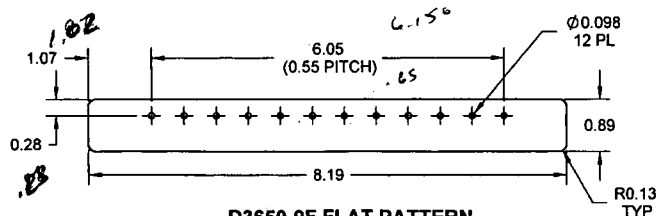
**D3650-11F FLAT PATTERN**



**D3650-9 ANGLE**  
(MAKE FROM D3650-9F FLAT PATTERN)



**D3650-7-8.19 SEAL**



**D3650-9F FLAT PATTERN**

**D3650-9 & D3650-11 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI.018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb  
D3650-11 WEIGHT: 0.007 lb

**D3650-7-8.19 NOTES:**

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)  
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI.018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX  
WHERE X.XX = LENGTH IN INCHES  
EG. 12.50" LONG = D3650-7-12.50

DEO ATTACHED

RELEASED  
07/17/14

UNDER REVIEW  
07/02/14  
OK 07/16/14

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	B		DRAWING NO.	REV. C
MFG. APPR.			D3650	SHEET 9 OF 9
APPROVED			TITLE	SCALE
DE APPR.			TOP PANEL ASSEMBLY	NTS
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DRAWING NO. D3650	TITLE TOP PANEL ASSEMBLY	REV. C	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>	D.E.O. NO. D3650-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN CP	CHECKED		MFG. APPR. <i>EC</i>	APPROVED <i>MD</i>	DE APPR. <i>MD</i>	
DATE 09.06.12	DATE 04.06.15		DATE 09.06.15	DATE 09/06/15	DATE 09/06/15	

**TO AMEND D3650-5 FWD PANEL:**

REF PAR 09-008. THE QTY(12) NAS1149CN432R WASHERS ARE REPLACED WITH QTY(1) D3893-1 DOUBLER. THE QTY(12) MS20615-4M5 RIVETS ARE REPLACED WITH QTY(12) NAS9307M-4-03 RIVETS. LOCATION OF THE DOUBLER IS SHOWN IN THE AMENDED DETAIL F (DWG SHEET 7) BELOW. THE PARTS LIST FOR D3650-5 IS AMENDED AS FOLLOWS:

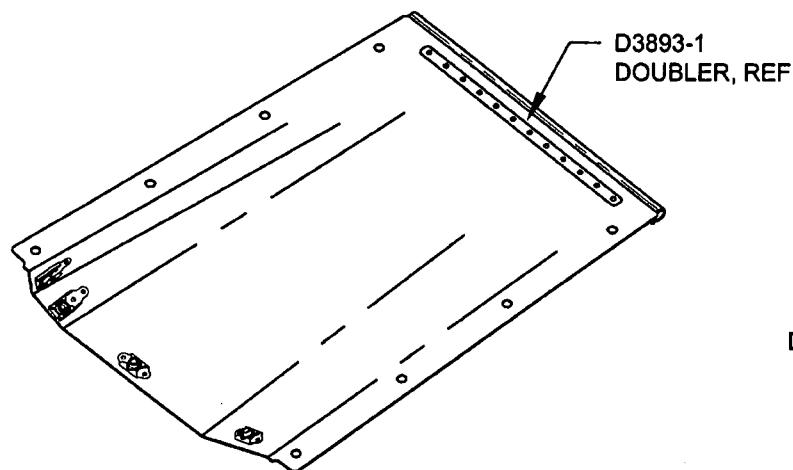
**IS:**

QTY	PART NUMBER	DESCRIPTION
-5		
1	D3893-1	DOUBLER
12	NAS9307M-4-03	RIVET (OR CR3523-4-03)

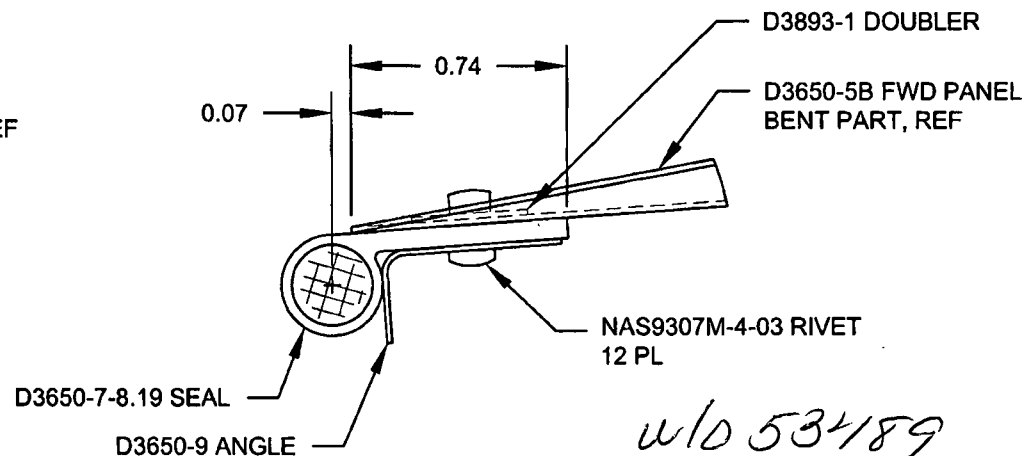
**WAS:**

QTY	PART NUMBER	DESCRIPTION
-5		
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET

**RELEASED**  
*09/06/15*



**D3650-5 FWD PANEL**



**DETAIL F** C5-7  
SCALE 3.5X